



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103140-101-1
Job Sheet 187620



Part No: RB T103140-101-1

Job Qty: 2 ea

Part Name: Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T103140-101 Rev. A IPP Rev. A 18.05.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Handfinish - 7 - BeadBlast	2 pcs	12/14/18	12/14/18	0.00	0.10	Handfinish - 1 - 1		EL
							Handfinish - 1 - 2		
							Handfinish - 1 - 3		
							Handfinish - 1 - 4		
							Handfinish - 1 - 5		
							Handfinish - 1 - 6		
							Handfinish - 1 - 7		
							Handfinish - 1 - 8		
							Handfinish - 1 - 9		
							Handfinish - 1 - 10		
							Handfinish - 1 - 11		
							Handfinish - 1 - 12		
							Handfinish - 1 - 13		
							Handfinish - 1 - 14		
							Handfinish - 1 - 15		
							Handfinish - 1 - 16		
							Handfinish - 1 - 17		
							Handfinish - 1 - 18		
							Handfinish - 1 - 19		
							Handfinish - 1 - 20		
							Handfinish - 1 - 21		
							Handfinish - 1 - 22		
110	Large Fab	2 pcs	12/14/18	12/14/18	0.00	0.40	Large Fab 3		EL
120	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC9		CPC
121	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC5		CPC
122	Small Fab	2 pcs	12/14/18	12/14/18	0.00	0.00	Small Fab-4		A.P.
123	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC5		
130	Outsource	2 pcs	12/14/18	12/14/18	0.00	0.00	Outsource13		
140	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		DEC 12 2018
150	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC6		DEC 18 2018
160	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2		38
170	QC21-SA	2 Ea	12/14/18	12/14/18	0.00	0.00	QC21		9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Op 105 - Bead blast remove paint

Descriptions: 110 - 1-Remove factory markings. 2-Weld as per DWG.

122 - 1-Proof load test to 15000 lbs. prior to finish. 2-Remove any marks left from testing.

130 - -Issue P/O to GROUPE ALTECH: P/O 042024 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required

160 - Bag and label

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T103140-101-5	Shackle	2 Ea (1 ea)	105-Handfinish - 7 - BeadBlast	128356
RB T103140-101-3	Plate	2 Ea (1 ea)	110-Large Fab	126060

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Handfinish - 7 - BeadBlast	RB T103140-101-5	2	2	0
110-Large Fab	RB T103140-101-3	2	3	0

Part Specifications

Specifications could not be found.

Plex 12/10/18 1:06 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



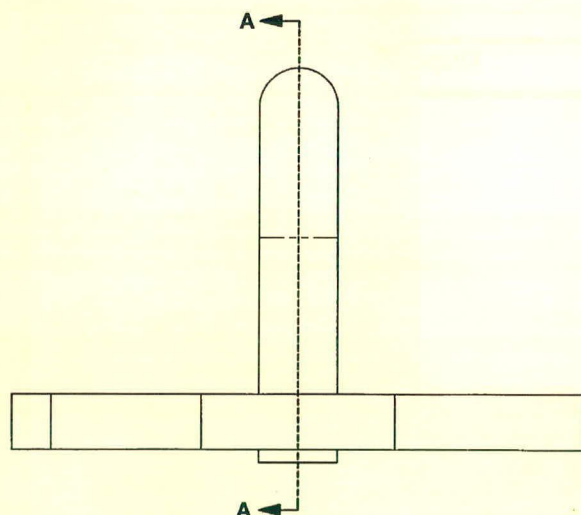
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

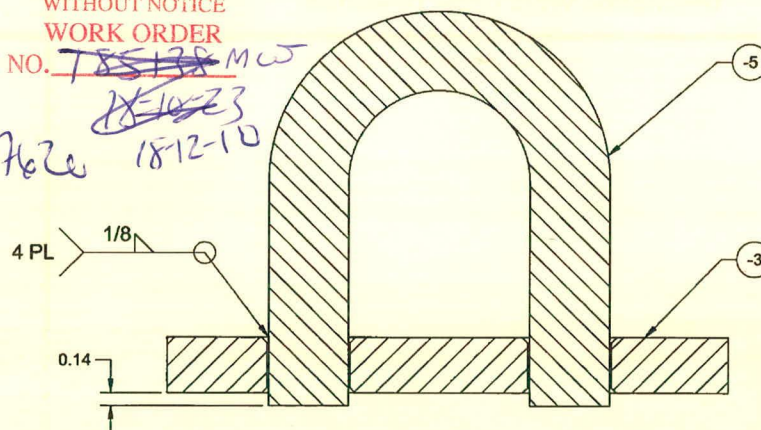
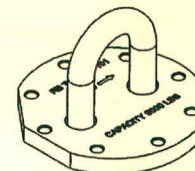
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
480620				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

ITEM #	QTY	PART #	PART TITLE
-3	1	RB T103140-101-3	PLATE
-5	1	RB T103140-101-5	SHACKLE



RB T103140-101-1 PLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~785138~~ MW
187620 1812-10



SECTION A-A

- NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) PROOF LOAD TEST TO 15000 LBS PRIOR TO FINISH

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/30/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/30/2018	RB T103140-101	SHEET 2 OF 6
APPROVED	ML 04/30/2018	TITLE	SCALE
DATE 5/8/2018		COVER AND LIFT ASSY - TRANSMISSION	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____



QA Closed: _____

Work Order update only ☐

Work Order: _____ Part No _____ NCR No _____ Date : _____	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Container No: S136339 Part: RB T103140 - 101 - 1 Job No: 187620 Serial No/Batch: S136339 Revision: A Inspector: _____ Exp Date: _____ Instructions: _____	Date: 12/10/18	INST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Welding</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>	Tube	☐	Water Jet	☐	Engineering	☐	Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Welding	☐	Supplier	☐			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Tube	☐	Water Jet	☐	Engineering	☐																								
Fab	☐	Prod. Eng. Coord.	☐	Quality	☐																								
Finishing	☐	Rec/Store/Packaging	☐	Other	☐																								
Welding	☐	Supplier	☐																										

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								



DATE: 2018/12/11

ZINK PLATING

MODEL: RB T103140-101-1

S/N : S136339

P/N	DESCRIPTION	QUANTITY
RB T103140-101-1	COVER AND LIFT ASSY	2

ALAN PATRY



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042024**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042024
PO Date: 12/12/18
Due Date: 12/19/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187620	RB T103140-101-1	Plate Assembly -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$45.00/pcs	\$90.00
					2x	DEC 18 2018					DAS 38 9-89
2	185463	RBE1120-31502W1-1	Base -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
					2x	DEC 18 2018					



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER **PO042024**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185464	RBE1120-31502W1-3	Top -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
						2 X		DEC 18 2018			
4	184975	RBW6305G01052-3G	Wrench, Main Gear Box Oil Pump Ring Nut Removal/Install -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/19/18	6 pcs	0 pcs	6 pcs	\$0.11/pcs	\$0.66
						6 X		DEC 18 2018			
Grand Total:											\$90.70

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/18/18 6:10 AM dart.belanger.natasha



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015336 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
15-Dec-2018		Ross Montieth		042024 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT103140-101-1 ✓ Rev.	RBT103140-101-1 01 - ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	2	2 ✓	0	0	0
2	RBE1120-31502W1-1 ✓ Rev.	RBE1120-31502W1-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0
3	RBE1120-31502W1-3 ✓ Rev.	RBE1120-31502W1-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0
4	RBW6305G01052-3G ✓ Rev.	RBW6305G01052-3G 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	6	6 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

